



## **COATING RECOMMENDATIONS**

*With Attached Product Data*  
**Coating System No. 15**

**For:** \_\_\_\_\_

**Date:** \_\_\_\_\_

**Prepared By:**

**WILKO PAINT, INC.**

### **SURFACE DESCRIPTION**

Steel surfaces operating with skin temperatures from 400°F to 1200°F. Examples: Turbine and engine exhaust systems, mufflers, stacks, hot piping, etc.

### **COATING SYSTEM**

Solvent-based silicone zinc primer with a "tack coat" and topcoat of high heat silicone aluminum (1000°F, intermittent to 1200°F).

### **SURFACE PREPARATION**

Remove weld splatter. Round off sharp edges. Remove oil, grease, dirt and other surface contaminants by high pressure water wash. Abrasive blast clean to N.A.C.E. #1 White Metal Blast. Use 16-40 U.S. Sieve series abrasive to produce 1.0-2.0 mils surface profile. For more information refer to "APPLICATION AND INSPECTION" towards the end of this catalog.

### **PRIME COAT**

**Product**  
**No. Coats**  
**Application**  
**Dry Film Thickness**  
**Wet Film Thickness**

809.01 Silicone Zinc-Rich Primer.  
One  
Conventional air spray with agitator pot  
2.5-3.0 mils  
3.5-4.5 mils

### **INTERMEDIATE COAT**

**Product**  
**No. Coats**  
**Application**  
**Dry Film Thickness**  
**Wet Film Thickness**

849.01 Silicone Aluminum (Colors)  
One (Tack coat)  
Roller or spray  
0.5 mils. Wet seal coat only  
1.5-2.0 mils

### **TOP COAT**

**Product**  
**No. Coats**  
**Application**  
**Dry Film Thickness**  
**Wet Film Thickness**

849.01 Silicone Aluminum (Colors).  
One.  
Roller or spray. Reduced as necessary.  
1.5-2.0 mils.  
3.0-4.0 mils.

**REMARKS:** See Technical Data Sheets for mixing instructions.

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### **ADDITIONAL INFORMATION**

#### **Zinc-Rich Primer Application**

The following instructions address the application of zinc primers prior and application of topcoats.

1. Zinc Rich Primer: Use conventional equipment with agitator-equipped paint pots for zinc rich applications. Zinc rich materials tend to pack in the pump in airless spray equipment. Avoid film build in excess of recommendations. Zinc rich coatings may mud crack if applied in too heavy coat. Apply a wet coat and avoid dusting.
2. Intermediate coat:
  - a. Reduce 849-01 Silicone Aluminum (or other silicone coatings) 50% with No. 1 Thinner and apply a wet coat – do not attempt to build a hiding coat with this first pass. If condition is still evident, increase thinning ratio to a 1-1 blend.
  - b. Allow the first coat to tack off before applying a full coat to eliminate bubbling and pinholing.
  - c. Multiple passes with the spray gun may be required to produce recommended film thickness of topcoats. The interval between passes may require extended time when applying at low surface or atmospheric temperatures.
2. Top Coat: Apply to specified film thickness. Do not attempt to build in excess.
4. For best results, cure the primer, intermediate coat and topcoat at the same time. Slowly increase service temperature to 350°F to 450°F over a six hour time period before exposing to high operating temperature to obtain optimum properties. Coating will remain thermoplastic for a period of time, especially at temperatures between 150 °F and 300°F, until exposed to high temperature for a length of time.
5. If the 809.01 is exposed to high temperature and is fully cured (nail hard), follow the following steps for topcoating:
  - a. Using aluminum screen, lightly rub areas where zinc dust overspray has embedded in the cured film. These areas are manifested by a rough, sandpaper-like texture. Screen the area to a smooth feel, avoiding excessive removal of zinc.
  - b. Following the above operation, remove residual dust from the entire surface with a stiff bristle brush. Do not use wire brush! Use tack cloth if necessary to remove surface dust.
  - c. If the operation does not effectively remove the dusty residue, apply a moderate pressure water wash. Do not use excessive pressure to avoid stripping the zinc coat.
  - d. If water wash is used, allow adequate drying time prior to topcoat application.
  - e. Follow with step #2 above.
6. Refer to technical data sheets on 809.01 Silicone Zinc Rich Primer and 849.01 Silicone Aluminum for further information